

Work Order ID 58517

Monday, May 10, 2010 8:13:37 AM



Page 1

Item ID: D3912-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Eyebolt Receiver Assembly

Start Date: 5/10/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/10/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3912

A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EP 5/10/05/10 (4)

110

0.00



Small Fab

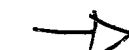
Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

*EP 5/10/05/10 (4)**SA 10/05/10 (4)*

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*SC 10/05/10**(44)*

W/O:			WORK ORDER CHANGES					
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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 507

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Proprio (4)

10/05/10
MF
10-5-10

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NOTE: Date & initial all entries

Picklist Print

Monday, May 10, 2010 8:13:34 AM

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2

Work Order ID: 58517



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 5/10/2010

Required Date: 5/10/2010

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS21209C6-10

Purchased

No

Each

63.0000

1



Heli Coil, screw locking, red



EP 5/10/05/10

Location

Loc Qty

Loc Code

ST304

23

108847

20

113705

3

ST305

40

114310

40

4

D3912-3

Manufactured

No

100

Each

10.0000

2



Eyebolt Block



EP 5/10/05/10

Location

Loc Qty

Loc Code

ST096

10

58094

10

D3912-5

Manufactured

No

100

Each

14.0000

2



Eyebolt Plate



EP 5/10/05/10

Location

Loc Qty

Loc Code

ST096

14

58095

14

D3912-1

Manufactured

No

100

Each

0.0000

1



Eyebolt



EP 5/10/05/10

B 58411 (40)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, May 10, 2010 8:13:34 AM

Page 2

Work Order ID: 58517

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Comments: IPP RevA: new issue DD 09.11.18 verified by:EC

Start Date: 5/10/2010

Required Date: 5/10/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS20615-4M20  RIVET		Purchased	No			100	Each	204.0000	8		5/10/05/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST323		204						
				113254		16						
				114324		4						
				114349		184						
D3810-1  Hand Retractable Spring Plunger		Manufactured	No				Each	35.0000	1		5/10/05/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST090		35						
				54523		1						
				57319		34						
D4028-041  Spring Pin Lanyard Assembly		Manufactured	No				Each	4.0000	1		5/10/05/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST109		4						
				53988		4						

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Shop Packet Print

Page 2

W/O:			WORK ORDER CHANGES					
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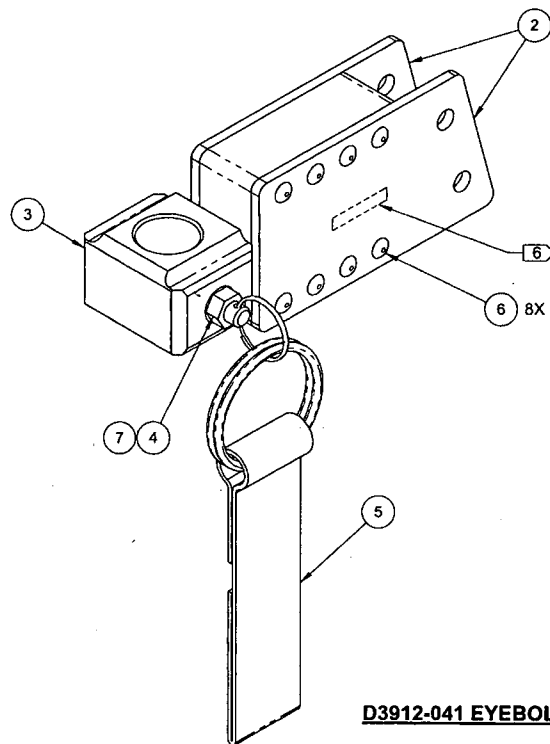
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

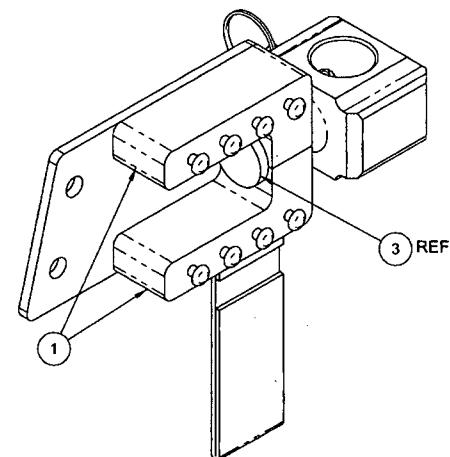
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	2	D3912-3	EYEBOLT BLOCK
2	2	D3912-5	EYEBOLT PLATE
3	1	D3912-1	EYEBOLT
4	1	D3810-1	SPRING PLUNGER
5	1	D4028-041	SPRING PIN LANYARD ASSY
6	8	MS20615-4M20	RIVET
7	1	MS21209-C610	HELICAL (RED LOCKING)



D3912-041 EYEBOLT RECEIVER ASSY



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -041: 1.68 lbs

REV.	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS		BY	DATE
DRAWN	JPH			
CHECKED	JP			
MFG. APPR.	JP			
APPROVED	JP			
DE APPR.	JP			
DATE	10.03.04			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. A
SHEET 1 OF 3

TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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55517

RELEASED
2010-03-12
MP

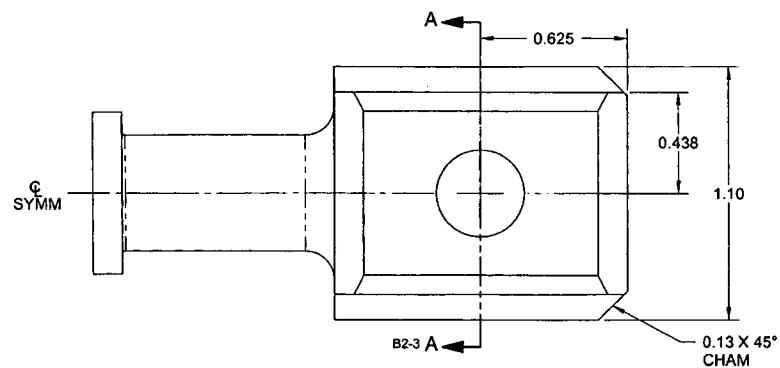
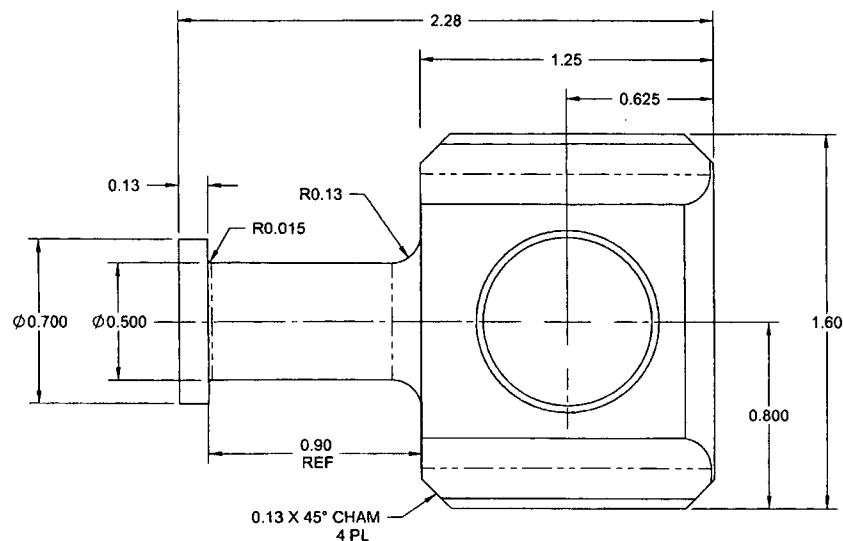
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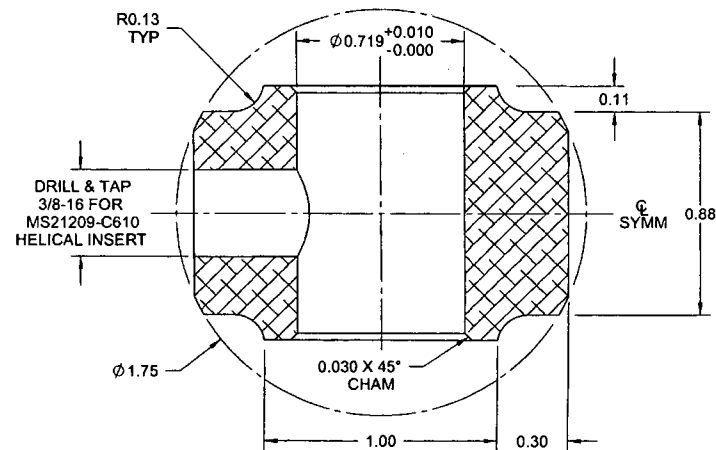
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.49 lbs



SECTION A-A B6-3

RELEASED
2010-03-12
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D3912	SHEET 2 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	EYEBOLT RECEIVER ASSY	NTS
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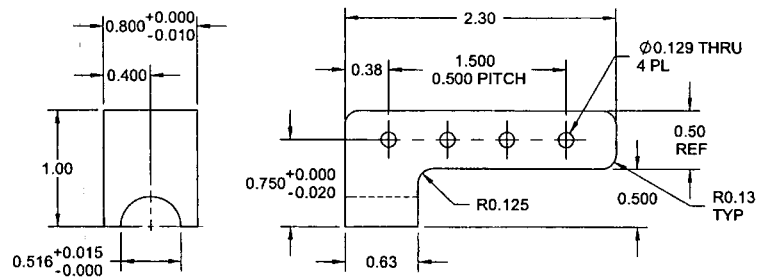
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

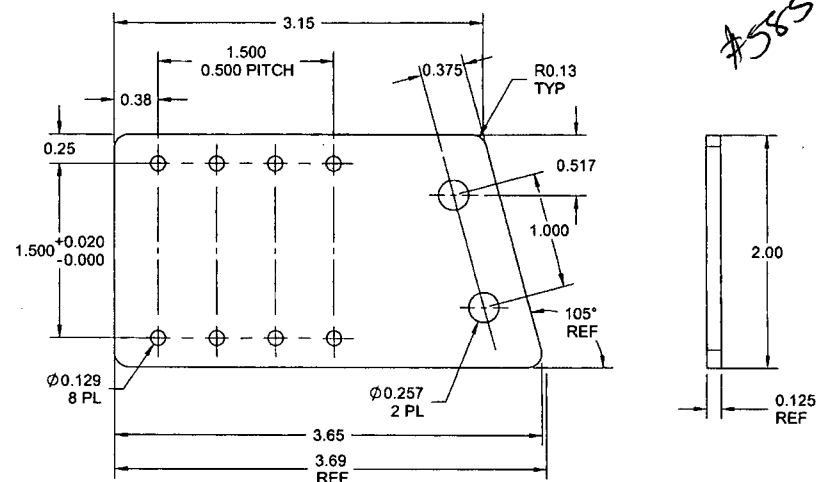
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ID AT ASSEMBLY

7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-03-12
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3912	SHEET 3 OF 3
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